

Date: Tuesday, 07/04/2009 10:20:40 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOOR PROTECTOR FWD LH
<b>Job Number</b> : 46975	
<b>Estimate Number</b> : 11227	
<b>P.O. Number</b> :	<b>Part Number</b> : D32811
<b>This Issue</b> : 07/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3281 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 44334	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/04/2009 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.04.07</u>	
<b>Comment</b> : Est Rev.A 04.07.01 New issue KJ/JLM Est. Rev B. 07.16.2007 Thermoform in house DL Est Rev C. 08.02.06 To reflect updated Dwg. DL Est Rev. D 08.04.15 Material Change DL	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
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**Comment:** Qty.: 4.3330 sf(s)/Unit Total: 25.9980 sf(s)  
 GE PLASTICS LEXAN SHEET

Material Batch Number M110877

BB 09/04/20

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 09/04/20 x6

3.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

Dwg. Rev. B  
 Folio Rev. B

BB 09/04/20 x6

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

BB 09/04/20 x6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:20:40 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR FWD LH

Job Number: 46975

Part Number: D32811

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/04/22 (X6)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/22 (X6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/22 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PPP. 46816

09/04/22 (X6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/23

Job Completion



09/04/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46215
<b>Description:</b> Floor Protector, Fwd LH		<b>Part Number:</b> D3281-1
<b>Inspection Dwg:</b> D3281	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

**Measured by:** JB **Date:** 09/04/22

#### TRIMMING SECTION

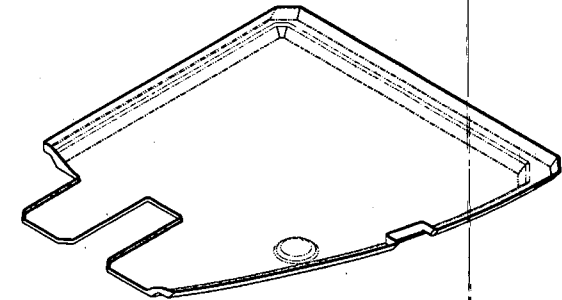
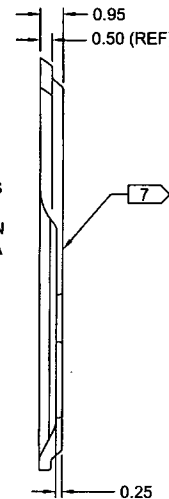
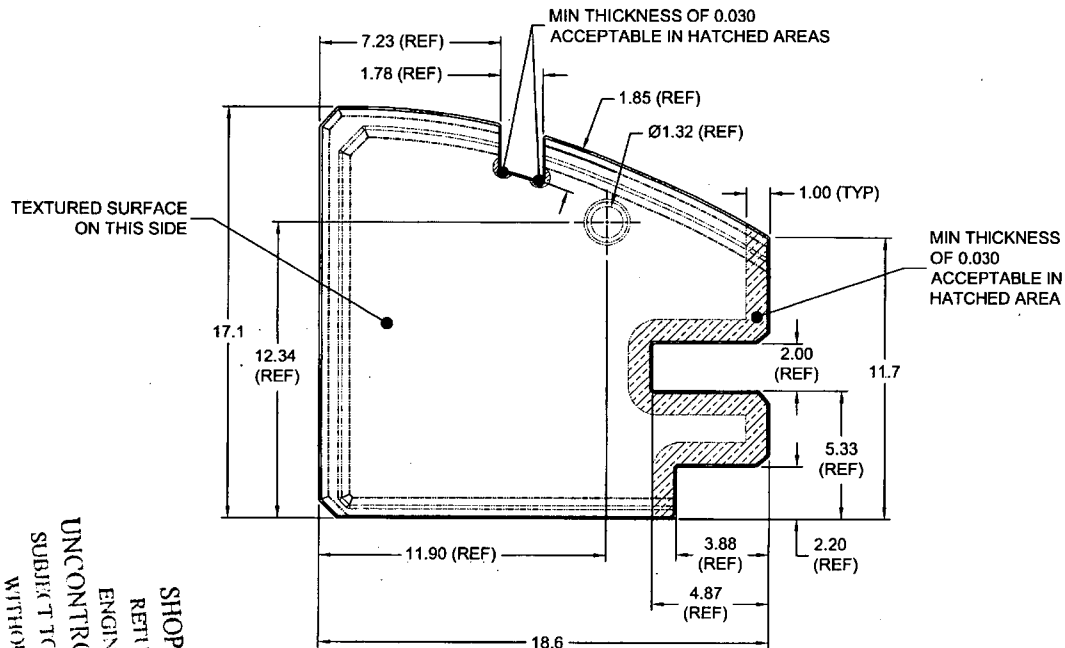
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	18.55	✓			
17.1	+/-0.100	17.1	✓			
11.7	+/-0.100	11.625	✓			
0.95	+/-0.030	.98	✓			
0.25	+/-0.030	.256	✓			
0.030	Min	.059	✓			
0.070	Min	.083	✓			

**Measured by:** JB **Date:** 09/04/21

**Audited by:** JH **Date:** 09/04/21

**Prototype Approval:** N/A **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	



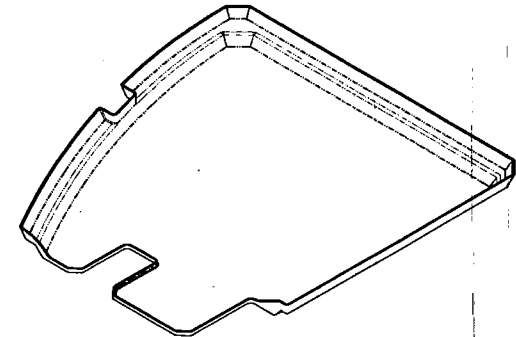
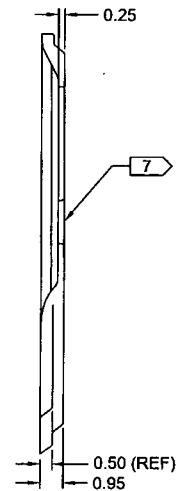
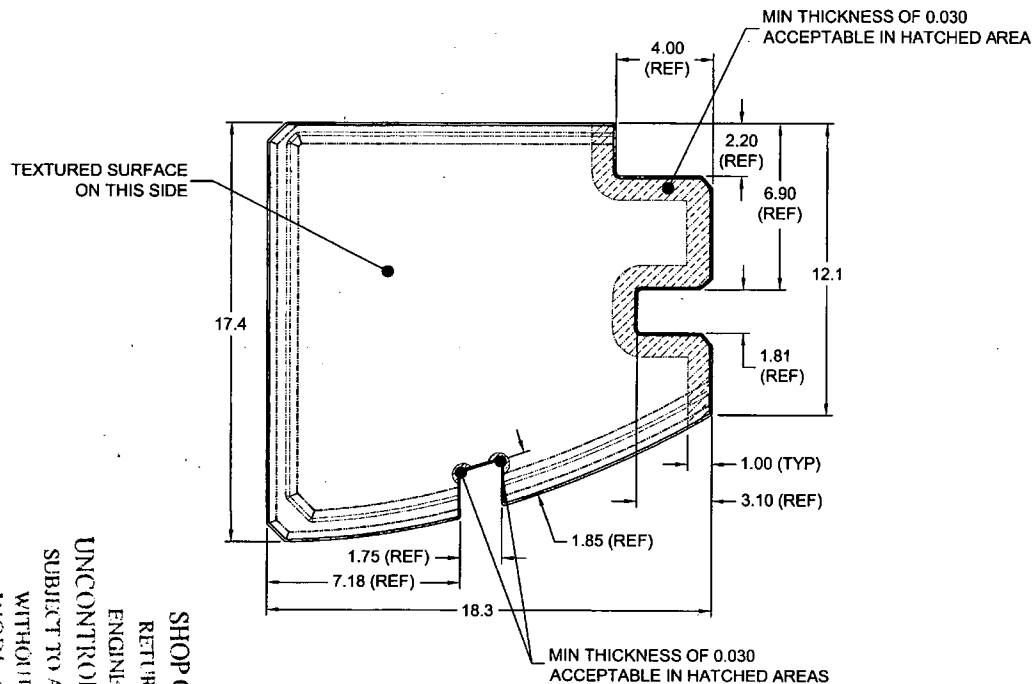
**D3281-1 FLOOR PROTECTOR**

- D3281-1 NOTES:**
- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
  - 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK (REF DART SPEC MLEXS.093-F6006-02)
  - 3) FINISH: NONE
  - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK SHARP EDGES: 0.010 MAX
  - 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
  - 8) WEIGHT: 0.95 lb

D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CF	05.11.25
A	NEW ISSUE	CF	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	92		
DRAWN	PH		
CHECKED	3		
MFG. APPR.	82		
APPROVED	100		
DE APPR.	11		
DATE	08.03.28		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3281	REV. D
TITLE FLOOR PROTECTOR	SHEET 1 OF 4
	SCALE NTS

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### D3281-2 FLOOR PROTECTOR

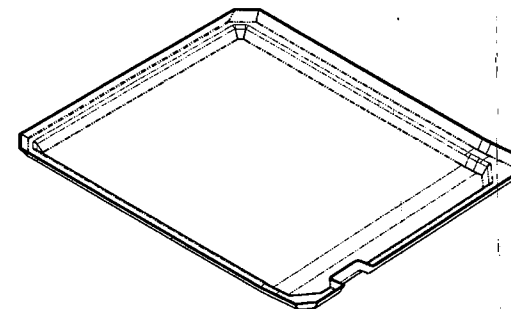
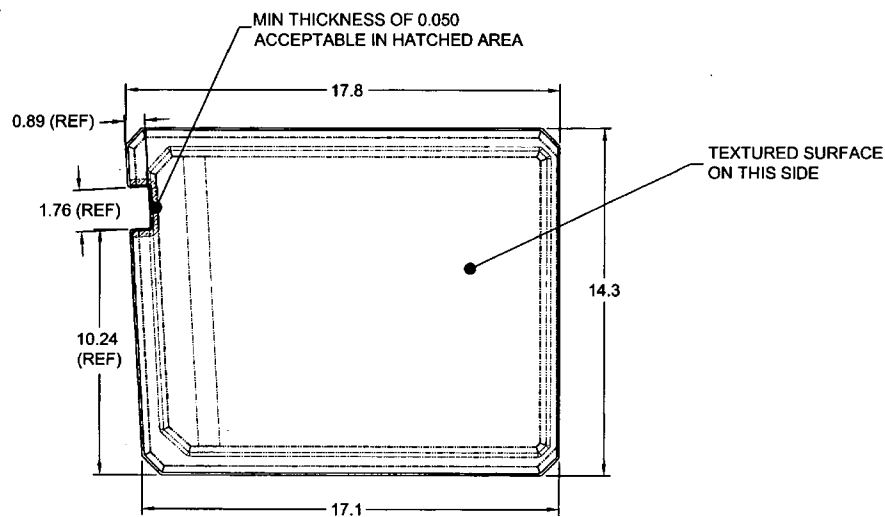
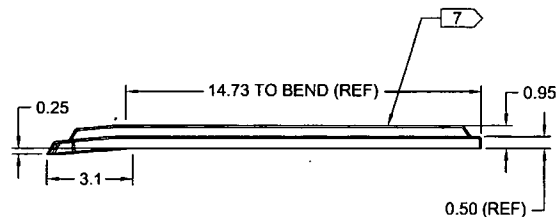
#### D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.97 lb

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN		DART AEROSPACE LTD
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CHECKED		DRAWING NO. REV. D
MFG. APPR.		D3281 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		FLOOR PROTECTOR NTS
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**D3281-3 FLOOR PROTECTOR**

NO. 4098  
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**D3281-3 NOTES:**

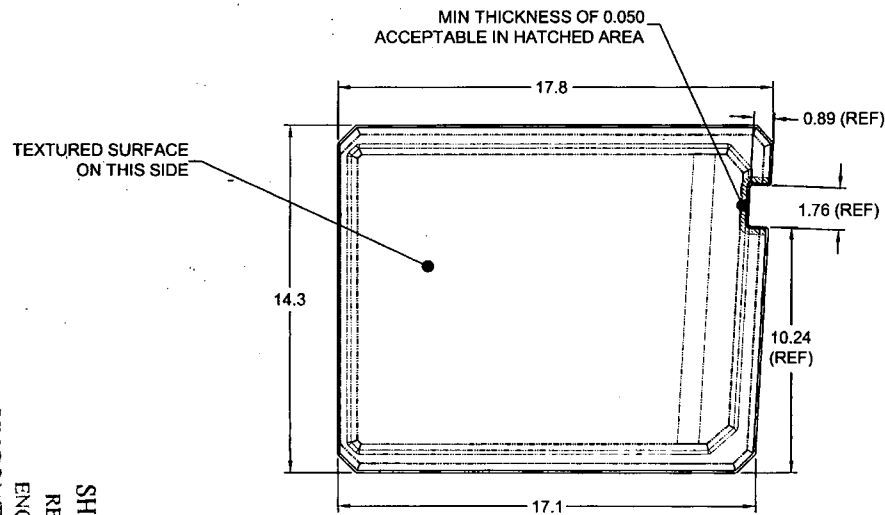
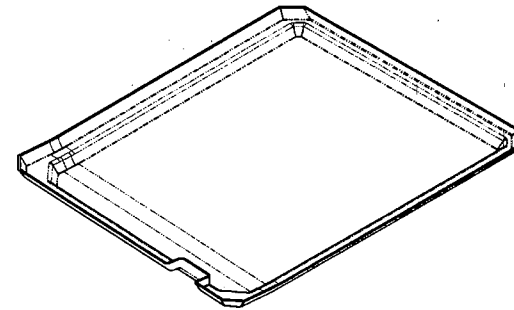
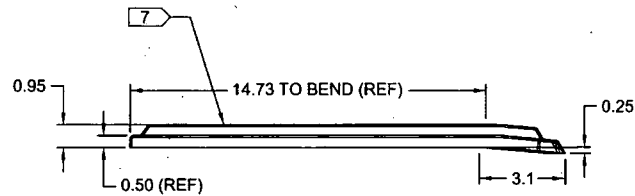
- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb



RELEASED  
08-04-11 MDP

DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	94	HAWKESBURY, ONTARIO, CANADA	
CHECKED	93	DRAWING NO.	REV. D
MFG. APPR.	90	D3281	SHEET 3 OF 4
APPROVED	94	TITLE	SCALE
DE APPR.	94	FLOOR PROTECTOR	NTS
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**D3281-4 FLOOR PROTECTOR**

**D3281-4 NOTES:**

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

RELEASED  
08-04-11 M.D.

DESIGN	42	<b>DART AEROSPACE LTD</b>	
DRAWN	44	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3281	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
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